Work Order II August-08-13 8:58:2			*105541*							
Item ID: D290 Revision ID: Item Name: Cap		30 x	Accept	*N900	040	100)* s	Setup Stai	1 71	S1* S2*
Start Date: 8/08/ Required Date: 8/08/ Reference:	13 Start Qty: 20	100 +20	*	Cust Item I Customer:	D:				IN	.7/
Approvals: Pro	cess Plan: MLJ	Date: 13-08-	08 Tooling:	Da	ate:		F	Run Stai	I/I	R1*
QC	:	Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								,	
D2964	Rev B									
100			0.00							
100 Waterjet FLOW CNC Waterjet 5052.080"	Dwg R Prog R	as per Dwg tev: 8 ev: 18 urr if necessary	0.00				30		<u></u>	<u>Ae</u> 13·12·10
120 *120* QC		off machine FAI/FAIB	0.00				_30			<u>Ae</u> 13:12.11

Quality Control

									DQA.	Date	•
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UPE	DATE	QA Closed:	 Date	
Work Orde	r:				DISPOSITION			AGAINST DE	<u> </u>	*************************************	•
Part N NCR N	lo				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Nen					work order opdate		- Large rab	composite[J	3dphici [_	
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initial Chief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data	Date	эсер	Qty		or won-comormance	Cilici Liig	Descr	iption	Date	Vermedion	Qe mspector
Equip/Tooling	:	}				:					
Operator											
Material	╗	ł									
Setup				1							
Other		!							İ		
Process	\neg	1									
Supplier											
Training											
Unapproved											
	•				F/	AULT CATE	GORY				
Landin	ng Gear			·,	General				_		
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced
	Centre N	ot Conce	ntric to	O/S	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks			L	Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
Į	Crushed/	'Crimped			Burrs	Instruc	tions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Trea	at			Countersink	Mislabe	eled		Positioned \	Wrong	<u>_</u>
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	/Surge	Other
	Ripples in	n Bend]	Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order August-08-13 8:5		5541	*105541*									Page 2	
Revision ID:	D2964 Cap			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*	
Start Date: 8 Required Date: 8 Reference:	8/08/13 8/08/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item II Customer:	D:				_			
		n:		Tooling: SPC (Y/N):		nte:			Run	Start Stop	"IVI	R1* R2*	
Sequence ID/ Work Center ID 130 *120 QC Quality Control 140 *120 Packaging Packaging	,	Operation Description QC8- Inspect parts - second Memo Identify as per dwg & Sto	16	Set Up/ Run Hours 0.00 DAS 27 0.00 9-89 0.00	Tool ID	Tool#	Code	Accept Qty 30	Qt	y 	Reject Number	Insp. Stamp	
150 *150* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00							2/11 <i>/</i>	4	
										N B	12-10		

NCR: Y	es /	No				WORK ORDER NON-	COI	VFORM	MANCE / UPD	ATE				
											QA Closed:	Date:		
Work Orde	er:		, - , , ,			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	Part No. NCR No. Root Desc					Rework Skid-tube Scrap Machining Use-as-is Thermoforming Work Order Update Large Fab			Machining noforming	Crosstube Small Fab Finishing Composite	→	Water Jet Engineering Prod. Eng. Coor. Quality /Store/Packaging Other Supplier		
Root					Descri	ption of work order update		Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							AUI	LT CATE	GORY					
Landir	ng Gea	ar			,	General								
	Cr Cr Cr Cr Lln	racks rushed/0 uffs eat Trea spection pples in	Crimped t n Strip in Bend			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete/U enance eled	inclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
1	l ITo	orque W	aves in E	Extrusion	·]	Drawing	1	Out of (Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

August-08-13 8:58:21 AM

Work Order ID:

105541

Parent Item:

D2964

Parent Item Name:

Cap

Start Date: 8/08/13

Required Date: 8/08/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B03.01.17Reformat; Dwg revisedKJ/RF WATER JET DD VERF:JLM

IPP REV:C 10.12.09 MADE ON

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.080 5052-H32 .080 Sheet	and the second s	Purchased	No			100	sf	80.0000	0.2361	4.970526	Ac	13	12.00
				Location		Loc Oty	Lo	c Code					

<u>Location</u>	Loc Qty
MAT022	80
124445	16
125552	64

						•			DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date	<u> </u>
Work Orde	· · · · · · · · · · · · · · · · · · ·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE					Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part N	o ·				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o		·	 	Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date 1	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other						1					
Process											
Supplier											
Training [
Unapproved										ļ	
			- 11.11		F	AULT CATE	GORY				
Landir	ng Gear				General				_		
į	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
	Heat Trea	at			Countersink	Mislab	eled		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offset					

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Drawing

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Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD			Work Order:	10554/
Description: Cap			 Part Number:	D2964
Inspection Dwg: D2964 R	ev: B	i		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

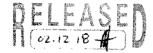
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.34	+/- 0.030	3,34	: ::		V	1Km-05
8.60	+/- 0.030	8.60	_		Τ.	JKM-05 JKM-06
0.080	+/- 0.010	1078	_			
	·	,				
	·					

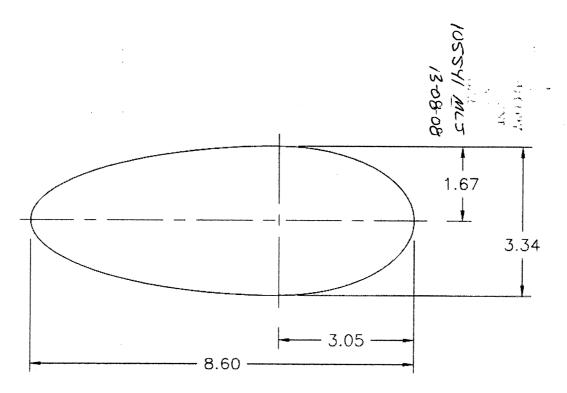
		DAS	
Measured by: Ae	Audited by:	27	Preliminary Approval:
Date: 13.12.10	Date:	13 12 lb	Date:

Rev	Date	Change	Revi	sed by	Approved
Α	10.12.20	New Issue	KJ	40	<i>X</i> X
				77	



DESIGN #		DRAWN BY	DART	RT AEROSPACE USA, INC.						
CHEC	KEDM	APPROVED	DRAWING NO.		REV. B					
	#	1	D2964	\$	SHEET 1 OF 1					
DATE			TITLE		SCALE					
02.1	12.18		CAP		1:2					
Α		00.02.24	NEW ISSU	JE						
В		02.12.18	REDESIGN	1						





NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8), 0.080 THICK (REF DART SPEC. M6061T6S.080 OR M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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